

Replacement Page 1, Title and 1st Paragraph

**Method for Producing Internally or Externally Profiled Rings
and Arrangement Therefor**

Description

BACKGROUND OF THE INVENTION

The invention concerns a method and arrangement for a combined forming and machine-cutting manufacture of internally and/or externally profiled rings from pipe (tubular) material or solid material by means of radial-axial pipe roll forming in combination with turning. The method and the arrangement serve for manufacturing, inter alia, cylindrical starter rings, rolling bearing rings, and transmission rings or the like.

Replacement Page 4, Paragraph Lines 15 to 19

SUMMARY OF THE INVENTION

In accordance with the invention, this object is solved for a method of the aforementioned kind ~~in connection with the features of the preamble of claim 1~~ in that during rolling of the profile a counterforce with regard to the flow direction of the pipe material is generated so that the material flow in axial and/or radial direction can be controlled such that the flowing material is incorporated into the shaping of the profile.

Replacement Page 5, Paragraph Lines 3 to 8

The object is solved furthermore by an arrangement ~~in connection with the features mentioned in the preamble of claim 6~~ for manufacturing internally and/or externally profiled rings, in particular rolling bearing rings and transmission rings in a completely grinding-ready state from pipe material or solid material, comprising a rolling device with an outer profile rolling tool and an inner profile rolling tool and optionally further devices for turning, in that the inner profile rolling tool has an axially moveable counterpressure tool for limiting the material flow which has a contact surface for the pipe to be formed which contact surface projects past the outer diameter of the inner profile rolling tool so that the material flow can be controlled in axial and/or radial direction.